

Work Order ID 65652

January 21, 2011 10:55:37 AM



Page 1

Item ID: D4185-5	Accept		Setup	Start	
Revision ID: PRELIM				Stop	
Item Name: Fly Stop, Lower					
Start Date: 1/21/11	Start Qty: 2.00				
Required Date: 2/04/11	Req'd Qty: 2.00				
Reference:					

Approvals:	Process Plan: <u>CL</u>	Date: <u>11/01/21</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4185	<u>PAT</u> PAT <u>11-01-28</u>								
100		0.00							
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	CUT BLANK 1.375" LONG								
110		0.00							
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	MILL AS PER DWG AND FOLIO FB018								
	FOLIO REV: <u>AA</u>								
	DWG REV: <u>P03</u>								
	2-DEBURR								



MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65652

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Item ID: D4185-5

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Fly Stop, Lower

Start Date: 1/21/11 Start Qty: 2.00



Cust Item ID:

Required Date: 2/04/11 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00		11/02/08		2	0		
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		11/02/22		2			
140 Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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January 21, 2011 10:55:37 AM



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Item ID: D4185-5 Accept Setup Start
 Revision ID: PRELIM Stop
 Item Name: Fly Stop, Lower
 Start Date: 1/21/11 Start Qty: 2.00 Cust Item ID:
 Required Date: 2/04/11 Req'd Qty: 2.00 Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

PL 11-06-9
(2)

POSITIVE RECALL

EFFECTIVE 1/21 AUTH h

RELEASED _____ DATE _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

January 21, 2011 10:55:37 AM

Work Order ID: 65652

Parent Item: D4185-5

Parent Item Name: Fly Stop, Lower

Start Date: 1/21/11

Required Date: 2/04/11

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 11-01-20 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.500X1.500		Purchased	No			100	f	39.4360	0.155	0.326316			



304 BAR .500 x 1.50



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	13.9	
116135	13.9	
MAT53	25.536	
✓113762	25.536	

0.3263 **

G.A 11/02/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 65652
Description: FLY STOP, LOWER		Part Number: D4185-5
Inspection Dwg: D4185 , Rev: PA3 PA5 PA7 11-02-23		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.48	+/- .030	0.475	✓		Vern	GA-01
0.05	+/- .030	0.050	✓		"	"
0.74	+/- .030	0.735	✓		"	"
1.06	+/- .030	1.059	✓		H-6	31006
1.19	+/- .030	1.189	✓		"	"
φ 0.125	+ .004 / - .001	φ 0.125	✓		Vern	GA-01
R0.06	+/- .030	R0.0625	✓		R-6	ref.
0.430	+/- .010	0.430	✓		Vern	GA-01
0.23	+/- .030	0.230	✓		"	"
φ 0.330 X 0.105	+/- .010	φ 0.331 X 0.105	✓		"	"
0.72	+/- .030	0.715	✓		H-6	31006
0.123	+/- .010	0.121	✓		Vern	GA-01
0.25	+/- .030	0.249	✓		"	"
0.154	+/- .010	0.154	✓		"	"
0.26	+/- .030	0.262	✓		"	"

Measured by: H.A.	Audited by: S.	Prototype Approval:
Date: 11/02/08	Date: 11/02/22	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

Receiving Report

Date: 10/01/20
 Supplier: MAGNA

Batch No: 7113762
 Dart P/O: 11155

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐
 Waybill Attached: Yes ☐ No ☒ N/A ☐
 Shipment Complete: Yes ☒ No ☐ N/A ☐
 QC6 Inspection ☒ N/A ☒
 Work Order 1116125

Discrepancies						
Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12

Production/Admin: 10/01/20
 Date
 Received/Costing
 Initial [Signature]

Location _____



Magna Stainless

5775 Kieran St, Saint-Laurent QC H4S 0A3
Phone: (514) 339-1211 Watts: 1-800-363-6646 Fax: (514) 339-1105

INVOICE

Pg 1 of 1 1022123

SOLD TO:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON
K6A 1K7

SHIP TO:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON
K6A 1K7

MTR:Y

INVOICE DATE:	01/25/10
ORDER DATE:	01/19/10
SHIP DATE:	01/25/10
ORDER NUMBER:	W024100
PURCHASE ORDER:	P011155

Currency		Sales Person		Ship Via		F.O.B.		Terms	
CANADIAN DOLLARS		ERYCK BLAIS		NIR:R-557065-1		PREPAID		NET 30 DAYS	
Ln.	Back Ordered	Ordered	Unit	Description		Shipped		Price Per	Value
		2	PC	STAINLESS PLATS SFL 304 HR 1/2" x 1-1/2" x R/L L035582 13'9" 2 PC/69 LB		2 UN		125.00	250.00

RECEIVED FEB 01 2010

01/26/10 13:24:53

PST Exmp No:EXEMPT

Merchandise:	250.00
Surcharges:	
No Tax Costs:	
GST	12.50
Total Due:	262.50

Title to the goods sent out on this invoice remains with Magna Stainless Div of CSM ULC until such time as this invoice has been paid in full. Unless otherwise noted terms are 30 days. Interest accrues on all overdue accounts at the rate of 1.5% per month compounded monthly.

Q.S.T. # 1213236471
G.S.T. # 881565899 RT0001

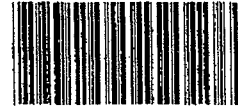
All amounts are calculated in domestic currency.

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M / Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
VendorID\Vendor Name		VC-MAG002	Magna Stainless								
PO11155	I		M304B0.500X1.500 f		1/22/2010	1/25/2010	27.8000	\$12.50	0.0000	0	\$347.50
CAD	No		304 BAR .500 x 2.50 f		20.0000	Stores		\$347.50	0.0000	0	
			113762								

Total Received Quantity:	27.8000
Total Qty to Inspect (PO U/M):	0.0000
Total Reject Quantity:	0.0000
Total Receipt Value:	\$347.50
Total Balance Due Quantity:	0.0000

**Magna Stainless**

5775 Kieran St, Saint-Laurent, Quebec H4S 0A3
Phone: (514) 339-1211 Watts: 1-800-363-6646 Fax: (514) 339-1105

**PACKING LIST**

Page 1 of 1

I022123

SOLD TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET

SHIP TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET

HAWKESBURY, ON
K6A 1K7
Contact: LINDA

HAWKESBURY, ON
K6A 1K7
Ship Terms: PREPAID



MTR:Y

SPECIAL INSTRUCTIONS

Currency	Sales Person	Customer Phone	Customer Fax	Customer PO	
CANADIAN DOLLARS	ERYCK BLAIS	(613) 632-5200	(613) 632-1053	P011155	
Sales Order	Terms	Ship Via	Date Ordered	Date Required	Date Shipped
W024100	NET 30 DAYS	NIR:R-557065-1	01/19/10	01/25/10	01/25/10

Ordered	Back Ordered	Unit	Description	Bundle #	Heat #	Shipped
2		PC	STAINLESS FLATS SFL 304 HR 1/2" x 1-1/2" x R/L 13'9" 69 LB / 2 PC	L035582	81459	2
Bundles: 1				Approx Weight:		69 LB

Received by: _____ Date: _____ Signature: _____

L Lacelle

From: Eryck Blais [eblais@magnastainless.com]
Sent: January 18, 2010 9:29 AM
To: 'L Lacelle'
Subject: RE: rfq
HI LINDA

2 PCS 125.00 EACH
DELAY 2-4 DAYS
THANK YOU
ERYCK

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: Monday, January 18, 2010 9:13 AM
To: Eryck Blais
Subject: rfq

20' x 304 bar .500 x 1.500

Thank You,
Linda Lacelle
Production Manager
Dart Aerospace Ltd

M304 B0.500 x 1.500
20' - 12.50/ft

MAGNA

1/18/10

M/S. VIRAJ PROFILES LTD.

F/QAD/08

VIRAJ[®]10 Imperial Chambers, 1st Floor,
Wilson Road, Mumbai 400 038
INDIA**TEST CERTIFICATE****CUSTOMER****ORDER NO****PACKING LIST NO****INSPECTION NO****DATE**

P00951

PROF/905647/18

100000252846

27.10.2009

GRADE**HEAT No**

304/304L

81459

BUNDLE NO :
5614337.**DESCRIPTION**

STAINLESS STEEL FLAT BARS

8
10/11/25**HOT ROLLED ANNEALED & PICKLED**

SIZE	SHAPE	TOLERANCE	LENGTH	PIECES	WEIGHT
1 1/2" X 1/2"	FLAT	ASTM A484	12' - 14'	42	1,473.000 LB

CHEMICAL ANALYSIS

%C	%Mn	%Si	%S	%P	%Cr	%Ni	%Cu	%Mo	%Co	%N2
0.0200	1.750	0.480	0.0200	0.0370	18.100	8.080	0.5600	0.3200	0.1300	0.08500

TEST RESULTS

Tensile strength ksi	0.2% Yield Strength ksi	% Elongation	% Reduction area	Hardness BHN	Grain size no
96.0	45.0	44.0	58.0	196.0	7.00

SPECIFICATION:

MATERIAL CONFORMS TO ASTM-A276-06 COND. A, ASTM A314, ASTM-A182-06 COND. A, ASME-SA182-01 COND. A, ASTM-A479/A479M-06a COND. A, ASME-SA479/A479M-00, COND. A, AMS-QQ5-763P, COND. A, ASTM-A484/A484M-06b, ASME-SA484/A484M-06, AMS-5639 H / AMS-5647 H, UNS-S-30400/UNS-S-30403. MATERIAL PASSES ICC TEST (FREE FROM CONTINUOUS CARBIDE) AS PER ASTM A262-02a3, PRACTICE 'B' GRAIN SIZE AS PER ASTM E112-96 (2004)c2. TEST CERTIFICATION IN ACCORDANCE WITH EN 10204:2005-3.1. STEEL MELTING PROCESS : INDUCTION MELTED & AOD REFINED. COLOUR CODE : RED.

REMARKS

FREE FROM RADIO ACTIVE CONTAMINATION, MERCURY CONTAMINATION, NO WELDING OR WELD REPAIRS. MACRO-SATISFACTORY. MICROSTRUCTURE-AUSTENITIC AS PER QQ5-763. SOLUTION ANNEALED TEMP.1050C. TREATED FOR 45 MINUTES & WATER QUENCHED. COUNTRY OF MELTING & MANUFACTURING:INDIA

We hereby certify that the material described above has been tested and complies with the terms of order/contract.

U.K. BARANWAL, GM(Q.A.)

P008682

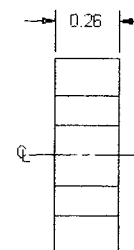
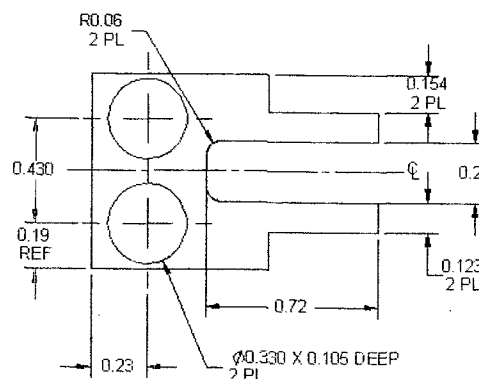
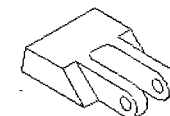
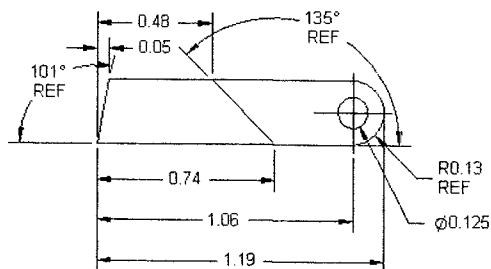
TRANSMISSION VERIFICATION REPORT

TIME : 02/28/2008 21:10
NAME :
FAX :
TEL :
SER.# : F9N212739

DATE, TIME
FAX NO./NAME
DURATION
PAGE(S)
RESULT
MODE

02/28 21:10
15143391105
00:00:17
01
OK
STANDARD
ECM

w/o 65652



D4185-5 FLY STOP - LOWER

NOTES

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR
PER ASTM A276
REF DART SPEC M304B
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

PRELIMINARY ISSUE

10.11.12

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA7
MFG. APPR.		D4185	SHEET 4 OF 9
APPROVED		TITLE	SCALE
DE APPR.		INTERNAL BELL CRANK	NTS
DATE	10.11.12	COPY RIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS HEREBY CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THE TITLE NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	